

Date: Tuesday, 16/09/2008 1:22:22 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR PANEL				
Job Number	: 42030							
Estimate Number	: 11401							
P.O. Number	:			Part Number	: D32961			
This Issue	: 16/09/2008		S.O. No. :	Drawing Number	: D3296 REV A			
Prsh Rev.	: NC			Project Number	: N/A			
First Issue	: / /		Type :	Drawing Revision	: A			
Previous Run	: 39874			Material	:			
Written By	:			Due Date	: 30/09/2008			
Checked & Approved By	: <u>Julie 08.9.16</u>			Qty:	12 Um: Each			
Comment	: Est C05.10.14 Added step 14 KJ/EC							
	: Est Rev:D Now on Waterjet 06-11-02 JLM							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 
		$108.279 \times 4 = 2.7$
		$5.54$
		$Batch: 108415 \times 8 = 88.8-17$
2.0	WATER JET	FLOW WATER JET 
		
		$1B 8-9-17$
		$D$
		$1-Cut as per Dwg D3296$
		$Dwg Rev: A$
		$Prog Rev: A$
		$1B 8-9-17$
		$2-Deburr if necessary$
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		$1B 8-9-17$
		
		$S 8-9-17$
4.0	QC8	SECOND CHECK 
		
		$S 8-9-17$
		$x12$
		$S 8-9-17$
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
		$Done at step #2.2$
		$Deburr$
		$8-9-17$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 1:22:22 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR PANEL

Job Number: 42030

Part Number: D32961

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



12x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/09/18

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



X1C

W

08-09-18

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

58180

C 08/18 (12)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/18 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42030
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **X First Article      Prototype**

Measured by: <u>RB</u>	Audited by: <u>  </u>	Prototype Approval: N/A
Date: <u>8-7-17</u>	Date: <u>08/08/17</u>	Date: N/A

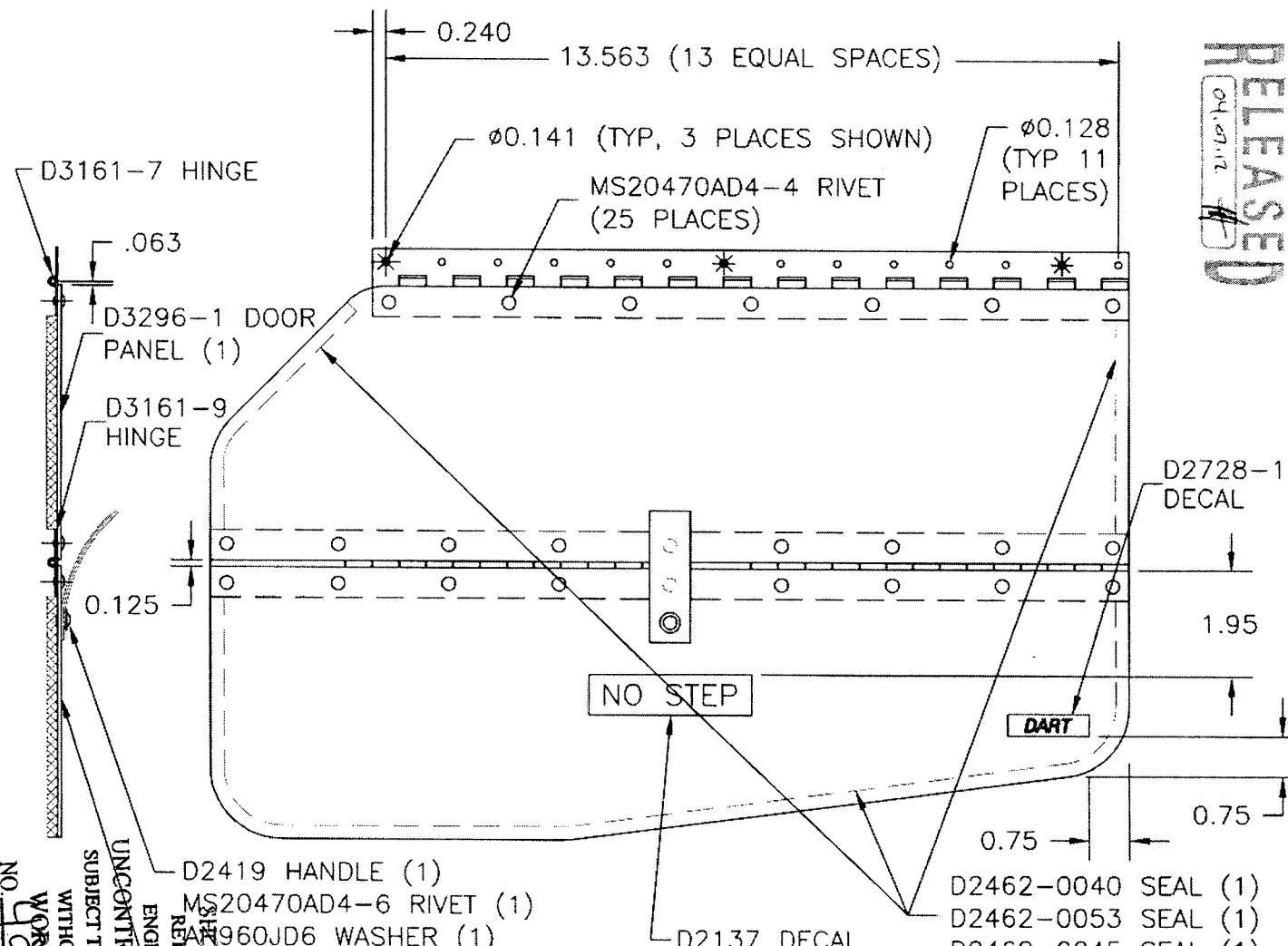
Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM  

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3296
DATE		REV. A
04.06.28		1 OF 2
		SCALE
		1:3

**RELEASED**  
04.07.07

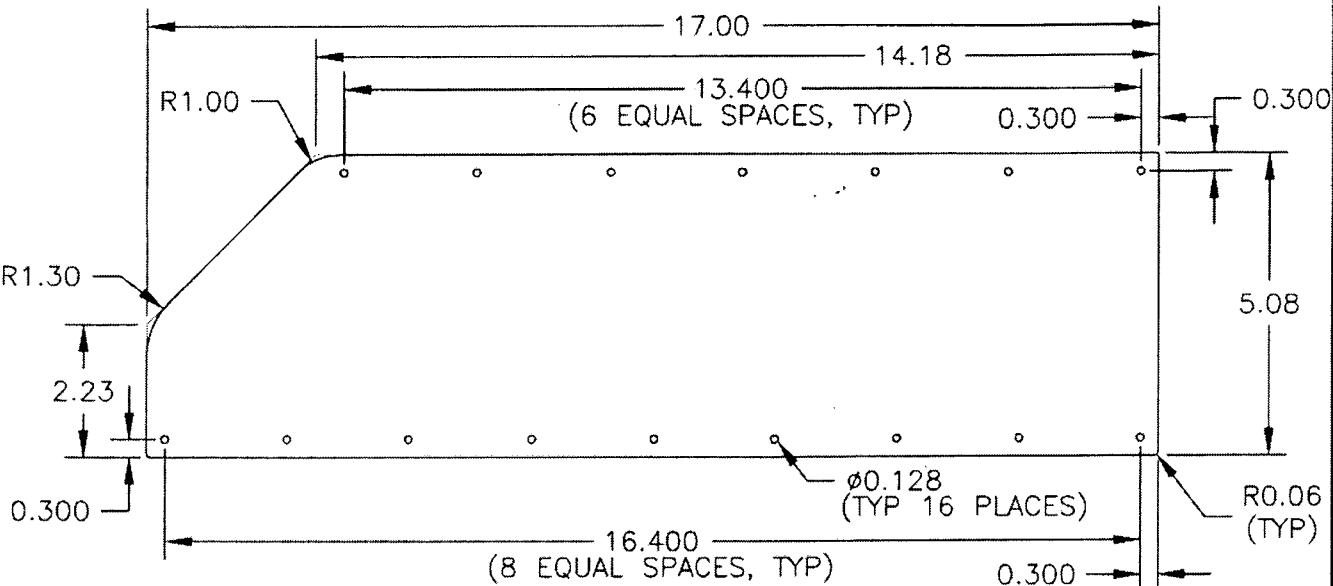


NO. WORK ORDER  
D3296-001 DOOR ASSEMBLY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
MSHP COPY

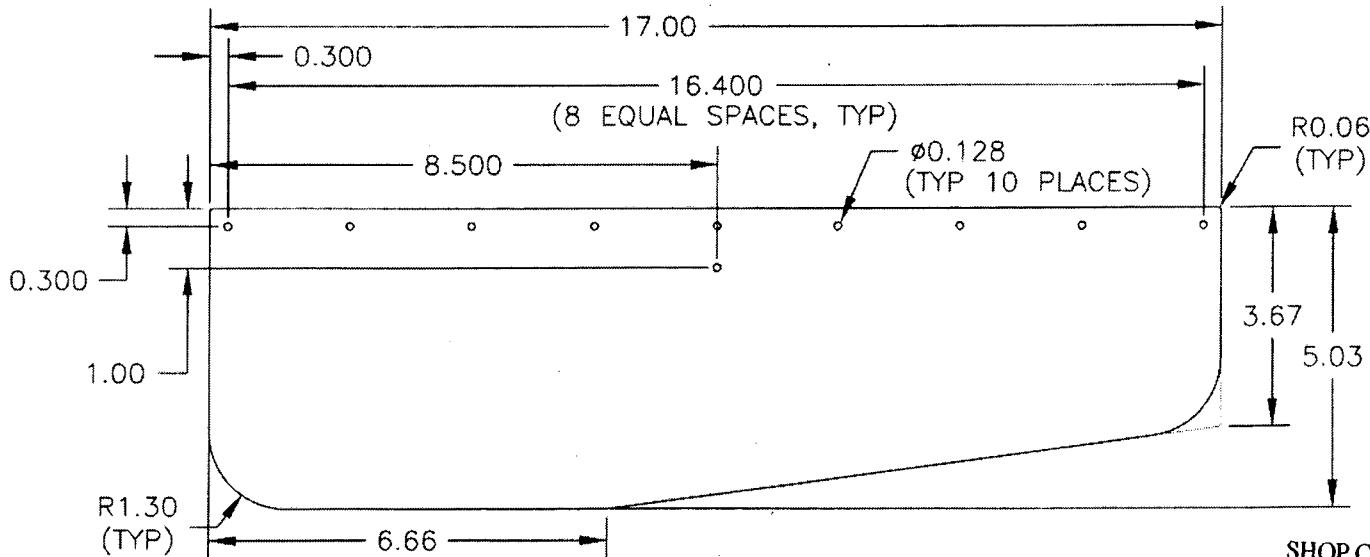
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3296	2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12  
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WITHOUT NOTICE  
WORK ORDER  
NO. 42030

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